



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D206-642-451
Job Sheet 197365



Part No: D206-642-451

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4361-043 REV A SHEETS 1,3,4, IIN-D206-642 REV Q SHEETS 31-32 IPP REV:A NEW ISSUE 13-06-13 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/29/19		0.00	3.70	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
115	QC 5	1 pcs	7/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
116	QC 10	1 pcs	7/29/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		

Plex 7/5/19 8:30 AM Dart.lajeunesse.marie

120	Handfinish - 1-1 Chemical-B4B	1 pcs	7/29/19	0.00 0.74	QC 10 - 9	
					Handfinish - 1 - 1 - B4B	<i>get 1-4-22</i>
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130	QC 7	1 pcs	7/29/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	<i>MB-6</i>
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	

				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
140 Skidtubes - 2 - B4B	1 pcs	7/29/19	0.00 3.70	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 5	1 pcs	7/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Skidtubes - 3 - B4B	1 pcs	7/29/19	0.00 3.70	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TE
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
180 QC 10	1 pcs	7/29/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	DAS JUL 26 2019 50 9-89
				QC 10 - 58	
				QC 10 - 9	
190 QC 5	1 pcs	7/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS JUL 26 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	

200 Handfinish - 2-1 Pressure- B4B	1 pcs	7/29/19	0.00 0.50	QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	ST JUL 27 2019
				Handfinish - 2 - 3 - B4B	
210 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/29/19	0.00 0.22	Handfinish - 2 - 4 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BL 19-7-30
220 QC 3	1 pcs	7/29/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	BL 19-7-30
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	7/29/19	0.00 0.74	Handfinish - 4 - 1 - B4B	BL 19-7-30
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	7/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
250	Packaging 3-1 - Stock - B4B	1	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B	JUL 31 2019
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
255	DC - 1 - B4B	1	7/29/19	0.00 0.00	DC - 1 - B4B	JUL 31 2019
	pcs				DC - 2 - B4B	
260	QC 21 - FG	1	7/29/19	0.00 0.00	QC 21 - FG - 21	JUL 31 2019
	pcs				QC 21 - FG - 70	
					QC 21 - SA - 53	
Part Op 110 - (Skid tubes) 1-Deburr Fwd edge of tube 3-Weld Fwd Cap as per Dwg D4361. Use aluminum rod. Grind D2647 to fit Descriptions: as required. 5-Cut aft end to length from front of tube 6-Drill pilot holes using drill jig DT8025 & DT8169 A-B-C-D 8-Open Aft cap hole using # 6 drill bit 9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-043 Drilling Detail 115 - (QC5- Inspect part completeness to step on W/O) 116 - (QC10- Inspect visual per QSI004- ground welds) 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7-Inspect Chemical Conversion Coat) 140 - (Skid tubes) 1-Open holes to finished size as per Dwg D4361, D4361-043 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D4361 (without cutting fluid) 4-Bond D2654-7 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting						

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Skidtubes) 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361.

Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

180 - QC10- Inspect visual per QSI004- ground welds)

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

220 - (QC3- Inspect Part Finish)

230 - (Assemble as per dwg) 1-Install wearplates as per dwg D4361. 7-Wing Walk as per Dwg D4361-043 and QSI 005 4.4

240 - (QC5- Inspect part completeness to step on W/O)

250 - Identify and pack for shipping as per PPP D206-642-451

255 - (Document Control) Photocopy bluefile and create labels per PPP D206-642-451 CHG001

260 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D2654-7	Web	1 pcs (1 ea)	140-Skidtubes - 2 - B4B
D2649	Cross Bolt Spacer	26 pcs (26 ea)	160-Skidtubes - 3 - B4B
AN3-36A	Bolt	10 Ea (10 ea)	230-Handfinish - 4-1-Assembly-B4B
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B
D2646	Aft Cap	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D2651-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D2651-3	O-Ring	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D2680-041	Nut Plate	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D3873-1	Bushing	20 pcs (20 ea)	230-Handfinish - 4-1-Assembly-B4B
D4366-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D4366-043	Run-on Landing Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21042-3	Nut use MS21042L3 per QSI 017	10 Ea (10 ea)	230-Handfinish - 4-1-Assembly-B4B
MS27039-1-08	Screw	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B
MS27039-4-06	Screw	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer (AN960C10L)	10 Ea (10 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149D0332J	Washer	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149D0463J	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B

011134

Container

5189572

5166098

D155207

5199364

FM133011

5099573

FM1378860

5160607

5196044

5180320

5197646

5193462

x 5201735

5201685

5149299

5162897

5166974-1

5193166

5178378

5055952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	9	0
	D2647	1	34	0
140-Skidtubes - 2 - B4B	D2654-7	1	6	0
160-Skidtubes - 3 - B4B	D2649	26	111	0
230-Handfinish - 4-1-Assembly-B4B	AN3-36A	10	79	0
	CCR264SS3-3	2	179	0
	CR3212-4-03	2	74	0
	D2646	1	25	0
	D2651-1	8	371	0
	D2651-3	8	291	0
	D2680-041	1	2	0
	D3873-1	20	94	0
	D4366-041	1	0	0
	D4366-043	1	0	0
	MS21042-3	10	513	0
	MS27039-1-08	2	421	0
	MS27039-4-06	1	91	0
	NAS1149C0332R	10	4,682	0
	NAS1149D0332J	2	3,250	0
	NAS1149D0463J	1	2,863	0

Part Specifications

Specifications could not be found.

Plex 7/5/19 8:30 AM Dart.lajeunesse.marie

8 7 6 5 4 3 2 1

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D4361-041	SKIDTUBE ASSY
		D4361-043	SKIDTUBE ASSY
1	1	D2800-1-160	EXTRUSION
1	1	D2854-5	WEB
1	1	D2854-7	WEB
1	1	D2846	AFT CAP
1	1	D2847	CAP
23	28	D2849	CROSS BOLT SPACER
4	8	D2851-1	PLUG
4	8	D2851-3	O-RING
1	1	D2880-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
1	1	D4368-041	FWD WEARPLATE ASSY
1	1	D4368-043	AFT WEARPLATE ASSY
8	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN860C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN860JD10L)
2	2	CR2846S83-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN860JD416)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197365
1105708
190708

RELEASED
R 2011-08-12 JWW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2854-5/7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
 - 8) WELD PER DART QSI 004
 - 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTATION TO POLISH UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE.
A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
 - 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
 - 11) INSERT D2851-1 PLUG C/W D2851-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE)

A	NEW ISSUE	DESCRIPTION	SC	BY	DATE
REV.					
DESIGN	SC				
DRAWN	SC				
CHECKED	SC				
MFG. APPR.	SC				
APPROVED	SC				
DE APPR.	SC				
DATE	11.05.05				
DART AEROSPACE USA, INC PORT HADLOCK, WA					
DRAWING NO. REV. A					
D4361 SHEET 1 OF 4					
TITLE SCALE					
208L/407 SKIDTUBE ASSEMBLIES NTS					
COPYRIGHT © 2011 BY DART AEROSPACE USA, INC					
THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE SPOT ON REQUEST WITHOUT FEE					
EXCEPT WHERE SHOWN OTHERWISE, ALL DIMENSIONS ARE IN INCHES					

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: <u>197365</u>		DISPOSITION		DEPARTMENT/PROCESS		Engineering ☒																																																																	
Part No. <u>0206-642-451</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Water Jet ☐ Supplier ☐ Quality ☐																																																																	
Date: <u>12/7/10</u>	Sequence #: <u>110</u>	QTY Affected: <u>1081</u>		MRB (Q51042) <u>12/7/10</u>																																																																			
Description Work Order Deviation		Disposition																																																																					
Ø 0.625 tooling hole is too small for 1.25		Ø 0.625 hole on dgs to be drilled Ø 0.640																																																																					
Root Cause		<table border="1"> <tr> <td>Operator</td> <td></td> <td>Pressure/Forced</td> <td></td> <td>Contamination</td> <td></td> <td>Power Loss/Surge</td> <td></td> </tr> <tr> <td>Manufacturing Process</td> <td></td> <td>Bending</td> <td></td> <td>Misaligned/off center</td> <td></td> <td>Folio/Program</td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td></td> <td>Crushing</td> <td></td> <td>BOM/Route</td> <td></td> <td>Grain Direction</td> <td></td> </tr> <tr> <td>Handling/Preservation</td> <td></td> <td>Cracks</td> <td></td> <td>Broken/Damage/Defect</td> <td></td> <td>Weld</td> <td></td> </tr> <tr> <td>Material</td> <td></td> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td></td> <td>Incomplete/Undeclared Instructions</td> <td></td> <td>Wrong Stock Pulled</td> <td></td> </tr> <tr> <td>Product Improvement</td> <td></td> <td>Marks/Chatter</td> <td></td> <td>Drill Holes</td> <td></td> <td>Out of Sequence</td> <td></td> </tr> <tr> <td>Process Improvement</td> <td></td> <td>Mislabeled</td> <td></td> <td>Fit/Function</td> <td></td> <td>Off-set/Set-up</td> <td></td> </tr> <tr> <td>Human Factors</td> <td></td> <td colspan="6">Other/Details:</td> </tr> </table>						Operator		Pressure/Forced		Contamination		Power Loss/Surge		Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Equip/Tooling		Crushing		BOM/Route		Grain Direction		Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Undeclared Instructions		Wrong Stock Pulled		Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up		Human Factors		Other/Details:					
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Human Factors		Other/Details:																																																																					
Completed By <u>12/7/10</u>		Lead hand / Supervisor																																																																					
QC / QA Coordinator <u>DAS 40</u>		JUL 27 2019																																																																					